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RB H4713-17
Job Sheet 201335



Part No: RB H4713-17

Job Qty: 4 pcs *10*

Part Name: Trans. & Gear Box Drain Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/31/19

Description:

Note: DWG RB H4713 Rev F IPP Rev A 18.02.23 New issue DP Verify DD/IPP Rev.B 19.02.27 drawing revision DP Verify DD/IPP Rev. C 19.04.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	4 pcs	10/31/19		0.00	0.80	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	4 pcs	10/31/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	4 pcs	10/31/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

GP 19-11-15
(small-fab-9)

DAS
NOV 19 2019
40
9-89

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
140 QC 21 - SA	4 pcs	10/31/19	0.00 0.00		QC 21 - SA - 21	21
					QC 21 - SA - 70	8-89
					QC 21 - SA - 53	

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Part Op 110 - 1-Cut RB H4713-11 as per drawing sheet 4. 2-Cut RB H4713-15 as per drawing sheet 5. 3-Assemble as per
 Descriptions: drawing note 7 and 8. 4-Pack as per drawing.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1887T48	Oil-Resistant Buna-N Foam Sheet, 1" Thick, 40" x 68"	.0560 sf (.014 ea)	110-Small Fab - 1	021250
2044T47	Tube Ø1.09 CORNER	1.2800 ft (.32 ea)	110-Small Fab - 1	016489142226
2044T67	Cap Ø1.09 49	8 Ea (2 ea)	110-Small Fab - 1	5192576
9263K642	O-Ring 46	4 Ea (1 ea)	110-Small Fab - 1	148081
RB H4713-1	Drain Hose Body 74	10 pcs (1 ea)	110-Small Fab - 1	125790

Job Allocations

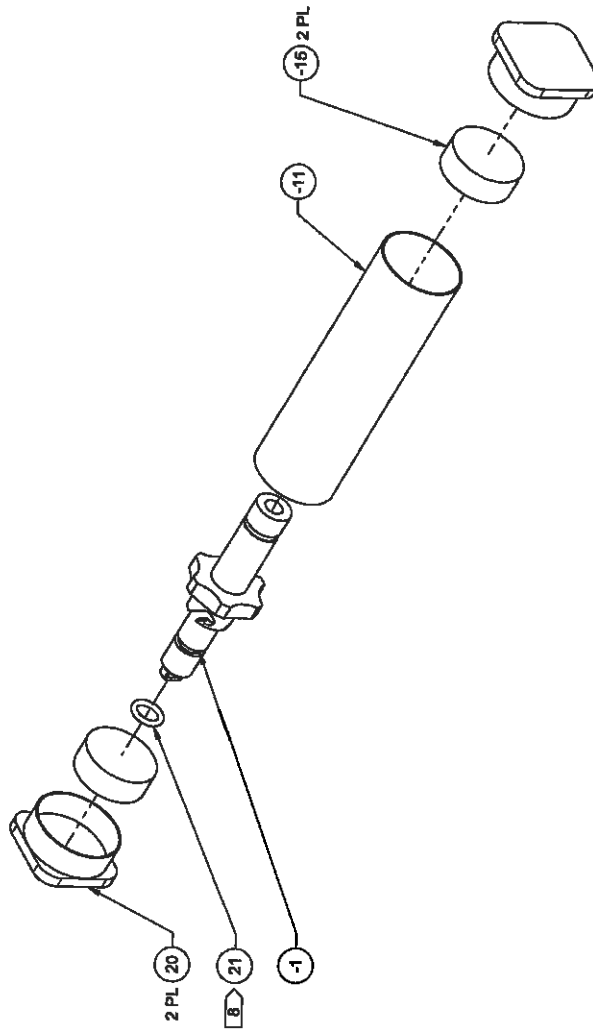
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	1887T48	0	13	0
	2044T47	1	17	0
	2044T67	8	133	0
	9263K642	4	31	0
	RB H4713-1	4	0	0

Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-1	1	RB H4713-1	BODY
-11	1	RB H4713-11	TUBE
-15	2	RB H4713-16	FOAM
20	2	McMaster#2044T87 OR EQUIV.	VINYL END CAP FOR 1.08" ID. SHIPPING TUBE
21	1	McMaster#9283K642 OR EQUIV.	VITON O-RING 7.8 mm ID. X 11.6 mm OD. X 1.9 mm WD.



RB H4713-17 TRANS. & GEAR BOX DRAIN TOOL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
UNITS: INCHES UNLESS OTHERWISE NOTED
IDENTIFICATION: N/A
ASSEMBLY AS SHOWN
APPLY MOLYKOTE 65 OR EQUIVALENT ON ITEM 21 THEN ASSEMBLE WITH ITEM -1 AND REMOVE EXCESS

DESIGN	MBB	DATE	4/24/2019
DRAWN	MBB		
CHECKED	KPT		
INFO. APPR.	DPT		
APPROVED	WAP		
TOOL PART #		RB H4713	
TITLE		TRANS. & GEAR BOX DRAIN TOOL MTS	
DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
REV. F		SHEET 2 OF 6	
SCALE		1:1	
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201335 MJS
19-10-01

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube Machining ☐ Large Fab ☐	Cross tube Small Fab ☐ Finishing ☐	Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				
Completed By		Lead hand / Supervisor			
QC / QA Coordinator					